

Date: Friday, 4/21/2006 10:12:22 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 205 SKIDTUBE "I" BEAM
Job Number : 26750	
Estimate Number : 10346	
P.O. Number : N/A	Part Number : D2596
This Issue : 4/21/2006 S.O. No. : N/A	Drawing Number : D2596 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : C
Previous Run : 26298	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 4/28/2006
Checked & Approved By : <u>SEE ABOVE USER & DATE</u>	Qty: 1300 Um: 45 Each
Comment : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D25003100	Ext'n -I' Beam Web 4"
-----	-----------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 15.0000 Each(s)

Extrusion "I" Beam Web 4"

Pick;

Qty	Part Number	Description	Batch
1	D2500-3-100	Extrusion	IT 06-04-21 (13)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1- Cut D2500-3-100 to length: 99.5"

2- Use Jig DT8093 to drill pilot holes #30

3- Open to 0.625" diameter using a uni-bit

4- Deburr

IT 06-04-20 (13)
 IT 06-04-24 (13)
 IT 06-04-24 (13)
 IT 06-04-25 (13)

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

IT 06-05-04 (13)

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

BE 06-05-04 (13)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PG

IT 06-05-04 (13)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *LD* Date: 06/05/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 4/21/2006 10:12:22 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 26750

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :


6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

 26/05/05 (13)

Job Completion



u 06-05-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

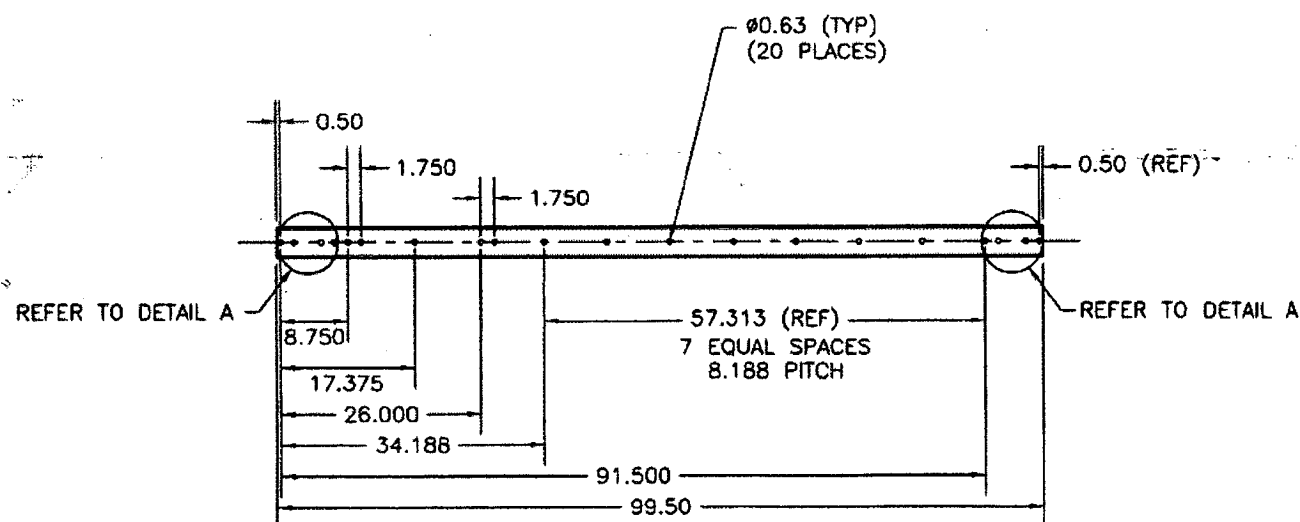
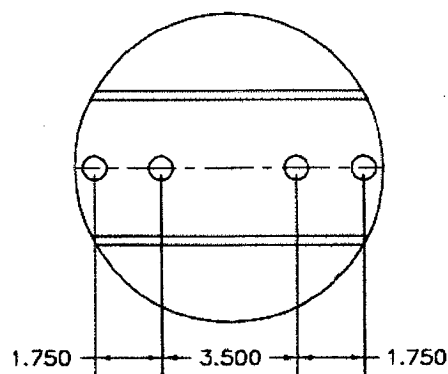
NOTE: Date & initial all entries

QA COPY ISSUED

98-09-17 bs

REFERENCE ONLY

DETAIL A
SCALE 5:24



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN <i>WJH</i>		DRAWING NO. D2596		REV. C
CHECKED <i>WJH</i>		APPROVED <i>WJH</i>		SHEET 1 OF 1
DATE 98.09.14		TITLE 205 WEB		SCALE 1:24
A	96.09.16	NEW ISSUE		
B	97.07.23	Ø0.63 HOLE WAS Ø0.56		
C	98.09.14	INCORPORATED DEO 9097		